

Date: Thursday, 2/22/2007 2:49:52 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OH-58 STEP ASSY RH *UNDER REVIEW**
Job Number	: 30794	Part Number	: D058677012
Estimate Number	: 12439	Drawing Number	: D2943 UNDER REVIEW
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 2/22/2007 S.O. No. : N/A	Drawing Revision	: UNDER Rev B AH 07.02.23
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Due Date	: 3/10/2007 Qty: 3 Um: Each
Previous Run	: 28723		
Written By	: <u>07.02.23</u>		
Checked & Approved By	: <u>07.02.23</u>		
Comment	: Est Rev: 01.04.11 Combined with D2943-041 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



(3)

Comment: Photocopy bluefile & type labels per PPPD058-677-012

CHG001

KS 07.03.01

2.0

D2622120C

Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Extrusion D2622-120C

Batch: 329607

LE 07.03.03

3

3.0

D2734

206 Step Endplate



* Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

D2734 206 Step Endplate

Batch: 327281 = 3 329340 = 3

LE 07.03.03

3

4.0

D2725

206 Step Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

D2725 206 Step Lug

Batch: B30882 DB20183 = 5

LE 07.03.03

3

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2943-1 from D2622 extrusion as per Dwg D2943

2-Deburr and bevel ends for welding

3-Weld end cap(1) and plate as per Dwg D2943 using Jig DT 8483

A/R AL ROD

Batch: M100237 M102225

LE 07.03.03

3

LE 07.03.05

3

LE 07.03.05

3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK-ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D058677012

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Grind end cap welds flush as per dwg D2943

LE. 07.03.08

3

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/03/09 (3)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/09 (3)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SS/mh 07-03-19 (3)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

LE. 07.03.20 3

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last end cap(1) as per Dwg D2943 using Jig DT 8482

A/R AL ROD Batch: *M100237*

LE. 07.03.20 3

2-Grind end cap welds flush as per dwg D2943

FF 07-03-20 3

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/03/20 (3)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/20 (3)

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Chemical Conversion Coat as per QSI 005 4.1

SS/mh 07-03-21 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 30794

Part Number: D058677012

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

POWDER COATING

POWDER COATING



M 103706



(3X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-h

07/03/21

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(3X)

Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2943 and QSI 005 4.4

Batch: M 103480

m-h

07/03/21

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/3/21 (3)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/21 (3)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

19.0

D27311

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Mounting Lug

Batch:

B9441 4X
B274192X

20.0

D27313

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Mounting Lug

B27420

21.0

D27315

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Mounting Lug

Batch:

B23330

W/O:		WORK ORDER CHANGES					
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Job Number: 30794

Part Number: D058677012

Job Number:



Seq. #:

Machine Or Operation:

Description:

22.0

D27317

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Mounting Lug

Batch: B 28936

23.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bolt

Batch: M100 243

24.0

AN412A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 24.0000 Each(s)

Bolt

Batch: M102929

25.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 36.0000 Each(s)

Washer

Batch: M103338

26.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 36.0000 Each(s)

Nut

Batch: M103349

27.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Do58-677-012

Location:

PPP Rev:

B 07/3/22 (3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/26

Job Completion



07.03.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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